

Work Order ID 117817

July-16-14 1:56:57 PM

117817

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split ① ship Friday 8/8 !!

Item ID: D2842-041

Revision ID:

Item Name: Step Assembly, 206 Float

Start Date: 5/05/14

Start Qty: 8.00

Required Date: 5/05/14

Req'd Qty: 8.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Q

Q

Approvals:

Process Plan: MLJ

Date: 140716

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2842

Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
2-Drill D2842-1 using Jig DT8271 as per Dwg D2842 ***DO NOT OPEN HOLES***
3-Deburr and bevel ends for welding

8

DLC 14-7-16

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

3

φ

14.08.06

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Item ID: D2842-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly, 206 Float

Start Date: 5/05/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 8.00

8

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Weld per dwg A/R Aluminum rod Batch: 125026
Large Fab 128886 0.00

120

Large Fab

Large Fab

Memo

0.00

1-Weld one end cap and (2) lugs using Jig DT10038 as per Dwg D2842

2-Grind end cap weld flush

3- Open hole as per dwg and deburr

3 Q DNC 14-08-07
DAS
43
9-89

130

QC9- Inspect visual per QSI004- Fusion Welds 0.00

130

QC

Quality Control

Memo

0.00

3 Q 14-8-7

140

QC5- Inspect part completeness to step on W/O 0.00

140

QC

Quality Control

Memo

0.00

SPC
14/8/7

3 Q 14-8-7

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Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 5/05/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Weld per dwg A/R Aluminum rod Batch: <u>125091</u>	0.00							
170									
Large Fab	Memo	0.00							
Large Fab	1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.								

3 DMC 14-8-7

③ 16 14-8-7 DAS 9 9-89

3x DMC 14-8-7 DAS 43 9-89 14-08-7

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Item ID: D2842-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Assembly, 206 Float

Start Date: 5/05/14

Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/05/14

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC10- Inspect visual per OSI004- ground welds

0.00

180

QC

Memo

0.00

Quality Control

③

14-08-07

DAS
9
9-89

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

③

14-08-07

DAS
9
9-89

191

Pressure Wash per OSI005 4.3

0.00

191

HandFinish

Memo

0.00

Hand Finishing

Touch up step with alodine per qsi 005 prior to powder coat

③

14-08-07 DMC

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Item ID: D2842-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Assembly, 206 Float

Start Date: 5/05/14

Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/05/14

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:00 PM
OVEN TEMPERATURE: 320°F
FINISH TIME: 12:30 PM

x3 f all 1408/07

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

R 0 76 1487

220

HandFinishing

0.00

220

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: 14129369

2x f 1408/07

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Item ID: D2842-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly, 206 Float

Start Date: 5/05/14 Start Qty: 8.00 *g*

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 8.00 *g*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89 11/08/08
230									
QC	Memo	0.00							
Quality Control									
240	Identify as per dwg & Stock Location: _____	0.00							
240									
Packaging	Memo	0.00							DAS 06 9-89 AUG 22 2014
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							
Quality Control									

14-08-26
MUS
14-8-25

Picklist Print

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Work Order ID: 117817

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C		Manufactured	No			120	Each	91.0000	1	8			
D2622-120C									**				
Step Extrusion													

Location	Loc Qty	Loc Code
HALL	32	
109575	32	
WA003	59	
101765	1	
<u>115141</u>	58	

D2734		Manufactured	No			120	Each	123.0000	2	16			
D2734									**				
Step End Plate													

Location	Loc Qty	Loc Code
WA003	123	
<u>119286</u>	86	
119498	36	
99709	1	

D3459-1		Manufactured	No			220	Each	9.0000	2	16			
D3459-1									**				
Float Step Mounting Plate													

Location	Loc Qty	Loc Code
WA003 <u>B121120</u>	9	
<u>113244</u>	9	

DHC 14-07-16

~~B 119286 → 8x~~

B 119286 → 3x 14-07-16

3

~~B 121120 → 16x~~

6

Picklist Print

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 8.00

Required Qty: 8.00

D3459-3 Manufactured No 120 Each 14.0000 2 16

D3459-3

Float Step Mounting Plate

**

14.08.06

Location Loc Qty Loc Code

WA003

14

113052

14

MS27039C1-07

Purchased

No

220

Each

83.0000

3

MS27039C1-07

screw

**

6
24
9

14.08.07

Location Loc Qty Loc Code

ST308

83

124580

6

m127305

27

m128401

50

NAS1149C0332R

Purchased

No

100

Each

5,228.000

3

NAS1149C0332R

WASHER

**

X9
24
9

14.08.07

Location Loc Qty Loc Code

GA

809

125654

809

Return2014

41

122063

41

ST279

600

m129390

600

ST292

628

125654

8

m128591

620

st510

3150

m126319

61

m127306

2500

m127410

563

m127831

26

11129909

X9

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Shop Packet Print

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Picklist Print

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 8.00

Required Qty: 8.00

NAS1329C3KB130

Purchased

No

220

Each

76.0000

3

NAS1329C3KB130

Insert

Location

Loc Qty

Loc Code

FP001

51

m126410

1

m127836

50

ST

25

296

25

NAS1515H3L

Purchased

No

220

Each

467.0000

3

***NAS1515H3I ***

Washer

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

427

m127831

155

m128976

272

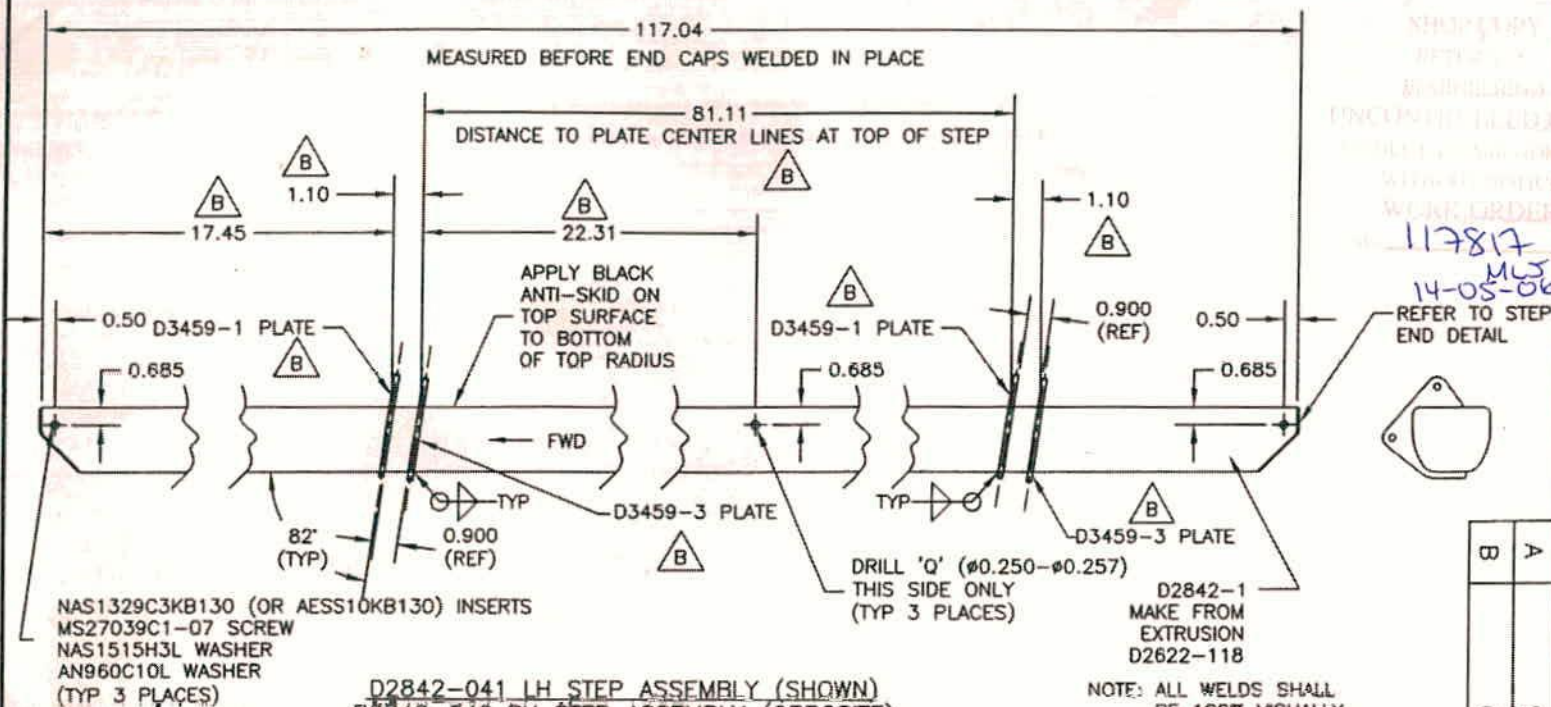
June-13-14 7:44:28 AM

Shop Packet Print

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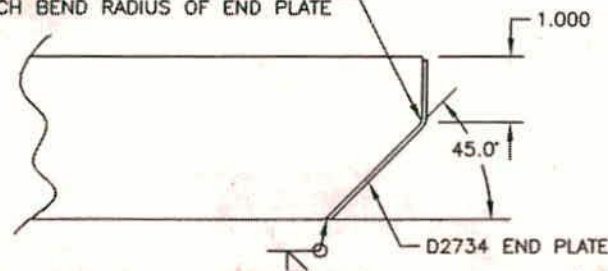
DART

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	RE-DESIGN, ADD D3459-1/-3
	A		98.10.13	206L/407 FLOAT STEP ASSEMBLY
	B		05.09.23	NEW ISSUE
				SCALE NTS

**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.11.14